W	ork	Order	ID	1111	12
* * *	VI 17	OIUCI			

111112

BF	K

Page 1

Thursday, January 09, 2014 11:28:19 AM Accept Item ID: D3440-1 *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Tube Guide (Supersedes B67-43001-25/-307) *10* **Start Qty: 10.00 Cust Item ID: Start Date:** 1/8/2014 **Required Date: 1/24/2014** Req'd Qty: 10.00 *10* **Customer:** Reference: Run Date: 14-01-09 Tooling: Date: **Approvals:** Stop Date: SPC (Y/N): Date: QC: Set Up/ Reject Sequence ID/ Operation **Tool ID** Tool # Plan Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Oty Number Stamp Draw Nbr **Revision Nbr** D3440 Rev A 0.00 100 **BAND SAW** *100* 0.00 Bandsaw Memo Cut blanks 4.200" long Jeaspa Bandsaw DAR 87 14-01-191 110 0.00 CONVENTIONAL MILLING MACHINE *110* 0.00 Mill Conv Memo Conventional Milling Machine Mill Blanks to 3.900" 0.00 120

0.00

120
HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio FA 551 and Dwg D3440

XIO 🗴

DP 14-01-07

MH 14-01-21

Work Order ID 111112

111112

Page 2

Thursday, January 09, 2014 11:28:19 AM Accept Item ID: D3440-1 *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Tube Guide (Supersedes B67-43001-25/-307) *10* **Start Date:** 1/8/2014 **Start Qty: 10.00 Cust Item ID:** Required Date: 1/24/2014 Req'd Qty: 10.00 *10* **Customer:** Reference: Run Start Tooling: Process Plan: Date: **Approvals:** Date: Stop Date: SPC (Y/N): Date: QC: *NP2* Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Accept Reject Reject Insp. **Work Center ID Description Run Hours** Code. Qty **Qty** Number Stamp 130 QC2- Inspect parts off machine FAI/FAIB 0.00 *120* 0.00 QC. Memo Quality Control 0.00 140 QC8- Inspect parts - second check D.A 14/02/18 *140* 0.00 Memo Quality Control Chemical Conversion Coarper 081005 4.1 150 *150* HandFinish 0.00 Hand Finishing

Work Orde Thursday, Janua				*111112*									
Item ID:	D3440-1			Accept	*N900	<u> </u>	100)*	Setup	Start	*NI	S1*	
Revision ID:					1 41. 71 71 71	, , —, ,		•		~.	1 1	.) !	
Item Name:	Tube Guide (S	upersedes B67-43001-25/	-307)							Stop	*N	S2*	
Start Date:	1/8/2014	Start Qty: 10.00	*10*	•	Cust Item II) ;							
Required Date:	1/24/2014	Req'd Qty: 10.00	*10*		Customer:								
Reference:										_	•		
Approvals:	Process Pla	n:	Date:	Tooling:	Da	te:	_		Run	Start	*N	R1*	
- 	QC:		Date:	_ SPC (Y/N):	Date:					Stop	*N	R2*	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp	
160		Green Sandtex(Ref:4.3.5.8) M 111 277	per QSI005 4.3	0.00				10	1	, ,,	, ,	M	
160 Powdercoat		Memo		0.00				10	_ <i>P</i>		1-2-/	7. g	8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8
Powder Coating			note 3 of dwg D3440S OVEN TEMPERATUR						,				
170		QC3- Inspect Part Finish		0.00								cAG.	
170 QC Quality Control		Memo		0.00				_10		\$		14.2.	- 19

180

Identify as per dwg & Stock Location: 100 0.00

180 Packaging

Memo

0.00

Packaging

Page 1

Thursday, January 09, 2014 11:28:15 AM

Work Order ID:

111112

Parent Item:

D3440-1

Parent Item Name:

Tube Guide (Supersedes B67-43001-25/-307)

Start Date: 1/8/2014

Required Date: 1/24/2014

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP A05.08.10New issueKJ/JLM

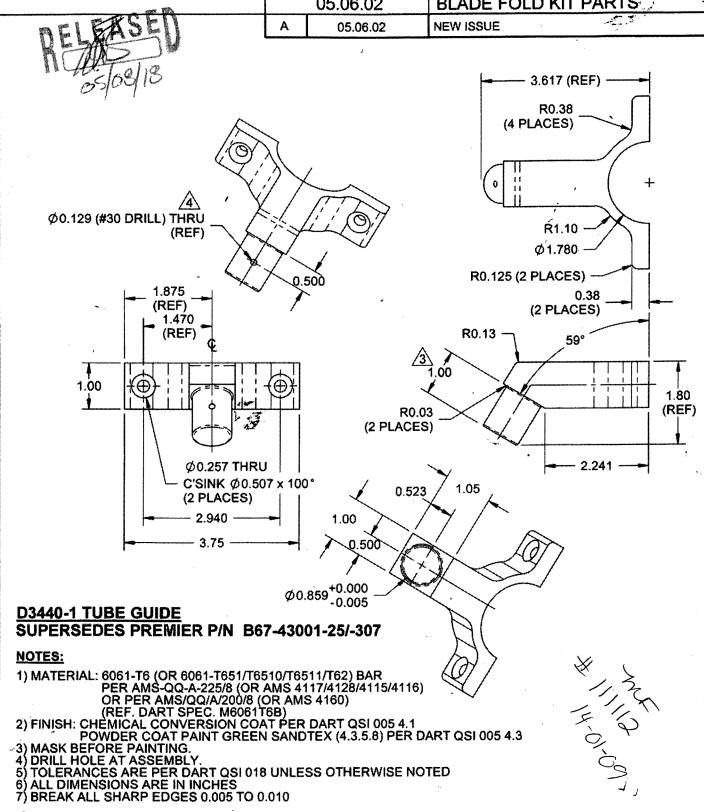
IPP B 08.06.24 Re-formated EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X04.000		Purchased	No			100	f	13.0000	0.37	4	· <u> </u>		
6061T6 Bar 2.00 x 4.00				Location		Loc Oty	<u>Lo</u>	c Code	1)A.C. 02 / Z	T (4-0,	1-19
				MAT009		13							
		•		11144	7	13			**	3.5			



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	1	1		
DESIGN	4	DRAWN BY	DART AEROSPACE LT HAWKESBURY, ONTARIO, CANAL	
CHECK	ф	APPROVED	DRAWING NO.	REV. A
*	4-		D3440	SHEET 1 OF 7
DATE			TITLE	SCALE
	05.0	06.02	BLADE FOLD KIT PARTS	1:2
Α	0	5.06.02	NEW ISSUE	



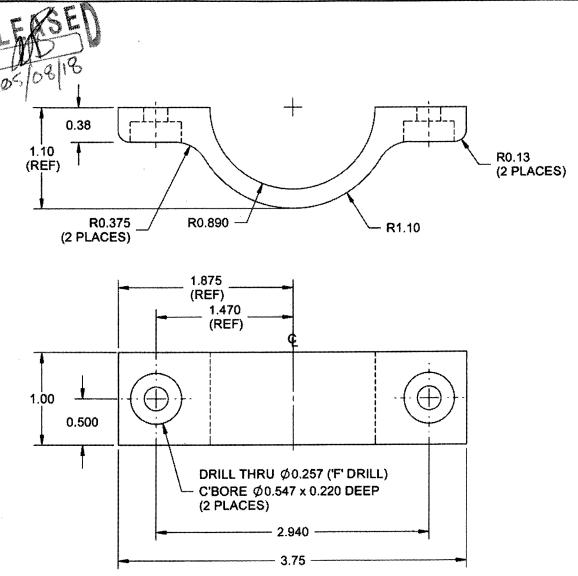
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DQA:			Date:												
_			•			WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE			AEROSPACE			
QA Closed:			Date:						V	Vork Order up	odate only				
Work Orde	r:	111 11	Z-			DISPOSITION			AGAINST DEPARTMENT/PROCESS						
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Part N	ο.	3440	-3	•		Scrap		ı	Machining Small Fab	Pro	d. Eng. Coor.	Quality			
	_				_	Use-as-is	Thermoforming Finishing			Rec/Sto	re/Packaging	Other			
NCR N	o					Suspected Unapproved			Large Fab Composite		Supplier				
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Process	긕	1			WOR	51.									
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Landin	ng G	ear				General									
[Bending				Bend		Folio/F	Program (Outside Dim	nensions	Pressure/Forced			
		Centre No	t Concer	ntric		BOM/Route		Grain	;	Over/Under	tolerance	Set-up			
		Cracks				Broken/Damage/Defect		Hardwa	are	Part Incorre	ci	Temperature/Cure			
		Crimp/Kin	ık/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified	Part Lost/M		Weld			
		Cuffs				Contamination	L	4	tions Incomplete/Unclear	Part Moved		Wrong Stock Pulled			
	Crushing				Countersink	\vdash	1	gned/off center	Positioned \		,				
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	'				Drawing	L	Misrea		·						
	├ ── │			Drill Holes	\vdash	Off-set									
						Finish	\vdash	-1	Calibration						
	Wave/Twist in Tube Fit/Function					Fit/Function		Out of	Sequence						



	- 1			
D	SIGN	DRAWN BY	DART AEROSPACE I HAWKESBURY, ONTARIO, CAN	
С	HECKED	APAROVED	DRAWING NO.	REV. A
	- 		D3440	SHEET 2 OF 7
D	ATE		TITLE	SCALE
	05	5.06.02	BLADE FOLD KIT PARTS	1:1

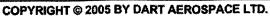


D3440-3 CLAMP SUPERSEDES PREMIER P/N B67-43001-309

NOTES:

1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0 005 TO 0 010

5) BREAK ALL SHARP EDGES 0.005 TO 0.010

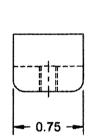


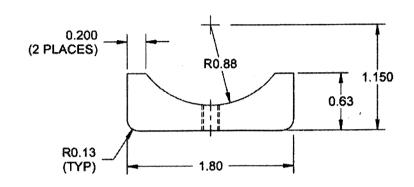
DQA:			Date:										DART.
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				A E R O S P A C E
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	r:					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
l com oran	•		 			Rework	ıl		Skid-tube Crosstube]	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab	_	Pro	d. Eng. Coor.	Quality
	•					Use-as-is			moforming Finishing		Rec/Sto	re/Packaging	Other
NCR N	Ю.					Suspected Unapproved]		Large Fab Composite			Supplier	
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		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unqualified		Part Lost/Mi	issing	Weld
		Cuffs			L	Contamination		4	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crushing					Countersink		-	gned/off center	L	Positioned V		-
	Heat Treat					Cut Too Short	<u></u>	Mislab			Power Loss/	Surge	Other
	Inspection Strip in Tube			Tube	<u> </u>	Drawing		Misrea					
	Marks/Chatter				<u> </u>	Drill Holes	Off-set						
	Turning Sequence				<u> </u>	Finish	 	-	Calibration				
	Wave/Twist in Tube					Fit/Function		Out of	Sequence				

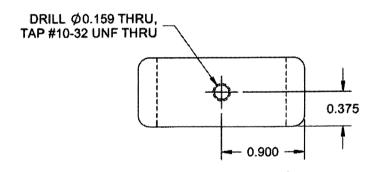


DESIGN DRAWN BY	DART AEROSPACE LT HAWKESBURY, ONTARIO, CANA	***
CHECKED APPROVED	DRAWING NO. D3440	REV. A SHEET 3 OF 7
05.06.02	BLADE FOLD KIT PARTS	SCALE 1:1









D3440-5 CONTOURED DETENT CLIP BASE SUPERSEDES PREMIER P/N B67-43001-217

NOTES:

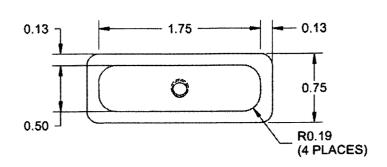
- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR PER AMS/QQ/A/200/8 (OR AMS 4160)
 (REF. DART SPEC. M6061T6B)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

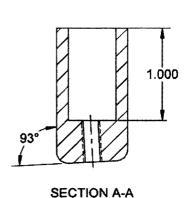
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		Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs	<u>_</u>	4 ·	tion Incomplete/Ui	· -	_	rt Lost/Mi	_		Weld
	Cuffs				<u> </u>	Contamination	<u> </u>	4	tions Incomplete/l	Jnclear		rt Moved		'	Wrong Stock Pulled
	Crushing			<u> </u>	Countersink		1	gned/off center		_	sitioned V		_		
	Heat Treat			<u> </u>	Cut Too Short	\vdash	Mislab		L	Po	wer Loss/	Surge [Other	
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1	Wave/Twist in Tube					Fit/Function		Out of	Sequence						

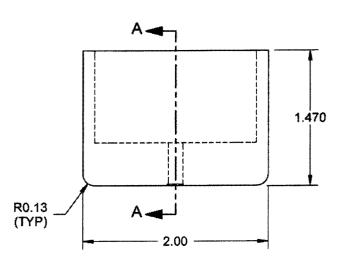


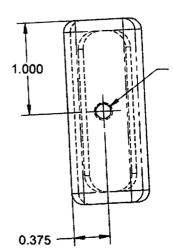
1		:	
DESIGN	DRAWN BY	DART AEROSPACE I HAWKESBURY, ONTARIO, CAN	
CHECKED	APPROVED	DRAWING NO.	REV. A
R	111112	D3440	SHEET 4 OF 7
DATE	WW T	TITLE	SCALE
05	.06.02	BLADE FOLD KIT PARTS	1:1











DRILL Ø0.159 THRU, TAP #10-32 UNF THRU

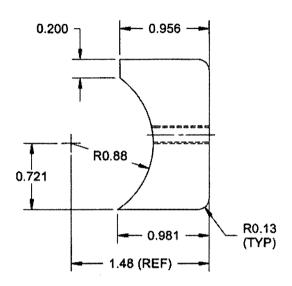
*///// <u>D3440-7 DETENT CLIP BASE</u> SUPERSEDES PREMIER P/N B67-43001-221 NOTES:

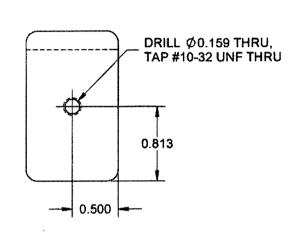
- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR PER AMS/QQ/A/200/8 (OR AMS 4160)
 (REF. DART SPEC. M6061T6B)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DQA:			Date:												
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			_		AEROSPACE	
QA Closed:			Date:							W	ork Order up	date only			
Work Orde	er:					DISPOSITION			AGAINST	AGAINST DEPARTMENT/PROCESS					
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Part N	۱o.					Scrap			Machining Small Fat	_	Prod. Eng. Coor.			Quality	
	•					Use-as-is Ther			noforming Finishing		Rec/Stor	e/Packaging		Other	
NCR N	NCR No.				Suspected Unapproved Large Fab C				; _]	Supplier				
Root					Desc	ription of work order update	П	nitial	Action		Sign &		T		
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		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	:i	Te	emperature/Cure	
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	Inspection Strip in Tube			Tube	-	Drawing	<u> </u>	Misrea				<u>-</u>		 	
	_	Marks/Cl			<u> </u>	Drill Holes	\vdash	Off-set							
	Turning Sequence				-	Finish	-	-1	Calibration			***			
1	1	Wave/Twist in Tube				Fit/Function		Out of	Sequence						



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DESIGN		DRAW	BY	DART AEROSPACE I	TD
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CHĘCK	D	APPRO	ÆD	DRAWING NO.	REV. A
*	4-	100	1	D3440	SHEET 5 OF 7
DATE				TITLE	SCALE
	05.	.06.02		BLADE FOLD KIT PARTS	1:1

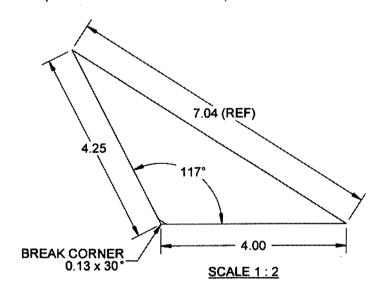




D3440-9 TUBE DETENT CLIP BASE SUPERSEDES PREMIER P/N B67-43001-241

1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS/QQ/A/200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B)







D3440-11 GUSSET

1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.250)

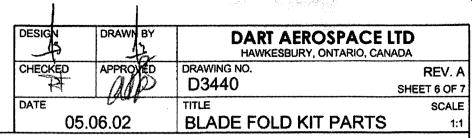
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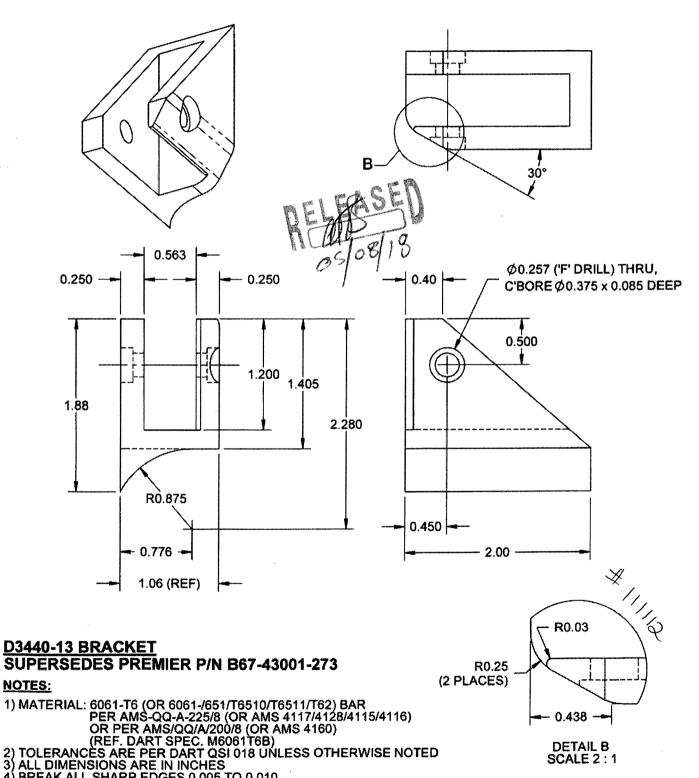
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DQA:			Date:					TRACT						
			. .			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only								
QA Closed:			Date:				Work Order apadate only							
Work Orde	er:					DISPOSITION				AGAINST	DEI	PARTMENT/PROCESS		
						Rework	1		Skid-tube Crosstube				Water Jet	Engineering
Part N	io.					Scrap		ı	Machining	Small Fab		Pro	d. Eng. Coor.	Quality
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NCR N	۱o. ₋					Suspected Unapproved			Large Fab	Composite			Supplier	
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	_	Cuffs		, TTUTE	-	Contamination		- 1	tions Incomplete/	•		Part Moved		Wrong Stock Pulled
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Inspection Strip in Tube				Drawing		Misrea				• ·				
Marks/Chatter				Drill Holes		Off-set								
		Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	ist in Tul	ое		Fit/Function		Out of Sequence						



4) BREAK ALL SHARP EDGES 0.005 TO 0.010





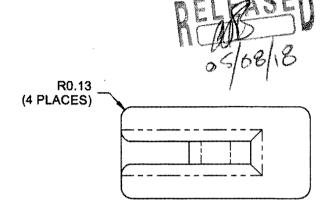
COPYRIGHT @ 2005 BY DART AEROSPACE LTD.

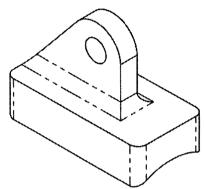
DETAIL B SCALE 2:1

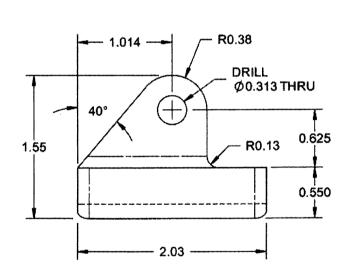
DQA:			Date:		***	,	TRAGG							
						WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only								
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Work Orde	er:					DISPOSITION	Ì			AGAINST DE	PARTMENT	PROCESS	,	
	-					Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering	
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	•					Use-as-is	1	Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other	
NCR No.					Suspected Unapproved			Large Fab	Composite		Supplier			
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Root		_	_	_	Desc	ription of work order update	ı	nitial	Actio		Sign &	\	061	
Cause	\dashv	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification	QC Inspector	
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		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	are	<u></u>	Part Incorre	ci	Temperature/Cure	
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	_	Cuffs				Contamination		-	tions Incomplete/Un	ıclear	Part Moved	_	Wrong Stock Pulled	
		Crushing				Countersink	_	-	gned/off center		Positioned V		¬	
	Heat Treat					Cut Too Short	\vdash	Mislab			Power Loss/	Surge	Other	
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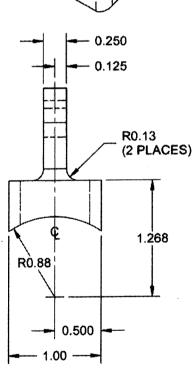


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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA						
CHECKED	APPROVEO	DRAWING NO. D3440	REV. A SHEET 7 OF 7					
DATE 05	.06.02	BLADE FOLD KIT PARTS	SCALE 1:1					









D3440-15 CONTOURED MALE EYE SUPERSEDES PREMIER P/N B67-43001-215

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
 PER AMS-QQ-A-225/8 (OR AMS 4160)
 (REF. DART SPEC. M6061T6B)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DQA: Date:													TQAR ^Z	
						WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:			Date:							W	ork Order up	date only		
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WOIK OIG	=1					Rework	ı 1		Skid-tube Crosstube			Water Jet	Engineering	
Part I	J۸					Scrap			Machining Small Fab	_	Pro	d. Eng. Coor.	Quality	
1 41111	•0.	<u> </u>				Use-as-is	1		noforming Finishing		l	e/Packaging	Other	
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		Crushing			-	Contamination Countersink	\vdash	4	gned/off center	\vdash	Positioned V	Vrong L		
	\vdash	Heat Trea	+		\vdash	Cut Too Short	-	Mislab		\vdash	Power Loss/		Other	
Inspection Strip in Tube			Drawing	\vdash	Misrea		Ш	J. 041Ci 2033/		100101				
	\vdash	1	•	·ubc		Drill Holes		Off-set						
Marks/Chatter			15	Щ	Off-set Out of Calibration									
			Finish		Out of	Calibration								

DART AEROSPACE LTD	Work Order: 1/1/10	
Description: Tube Guide	Part Number: D3440-	-1
Inspection Dwg: D3440 Rev: A	Page 1 c	of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.38	+/-0.030	2.375	/		RAS G	TAUGE
R1.10	+/-0.030	P1.10	/			AUGE.
Ø1.780	#• 678 	1.778	-		HEIGHT	1^
R0.125	+/-0.010	12.125	/		RAD GIV	
0.38	+/-0.030	,373			BUERN	DR 16
59°	+/-0.5°	59.	~		# PRO	BACTUR
R0.13	+/-0.030	R.175	/		RAD GO	
1.00	+/-0.030	.999	/		B'VERNO	DR 16
R0.03	+/-0.030	R.03			RAID C	HUNE.
2.241	+/-0.010	2.241	-		8 VERW	DR 16
1.05	+/-0.030	1.05	/		8'VERN	De16
0.523	+/-0.010	,5215	/		HEIGHT	GAUGE.
1.00	+/-0.030	1.001			8"voen	DRIG
0.500	+/-0.010	,501	/		HE 16 HT	GRUGE.
Ø0.859	+0.000/-0.005	8575			o-Imie	DP 01
1.00	+/-0.030	.997	_		8"0000	DR 16
Ø0.257	+0.006/-0.001	.259	~		Pin G	nuhe
Ø0.507 x 100°	+/-0.010 x +/-0.5°	,509	سن		9 VERN	D12 16
2.940	+/-0.010	2.936			8'VERN	DR16
3.75	+/-0.030	3.751	-		8"veren	DR16
"						

			<u> VAC</u>		
Measured by:	Audited by:	1.0	08	Prototype Approval:	N/A
Date: 14-01-27	Date:	14/021	18	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.07.23	New Issue	KJ/DD	<i>N</i>

DQA: Date:						·	TRAG						
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Work Order:			DISPOSITION		Ę	X	PROCESS						
	•				_	Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	ο.				<u> </u>	Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	e/Packaging	Other
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		Bending			<u> </u>	Bend		4 .	Program		Outside Dim	-	Pressure/Forced
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		Cracks			<u> </u>	Broken/Damage/Defect	_	Hardwa			Part Incorre		Temperature/Cure
		Crimp/Kii	nk/Ripple	/Wave	<u> </u>	Burrs	<u></u>	4 '	ion Incomplete/L	<u> </u>	Part Lost/M	issing	Weld
.		Cuffs			\vdash	Contamination	\vdash	4	tions Incomplete/		Part Moved	<u> </u>	Wrong Stock Pulled
		Crushing	_		<u> </u>	Countersink	-	-{ `	gned/off center		Positioned \	_	Jothan
		Heat Trea			\vdash	Cut Too Short	\vdash	Mislab		L	Power Loss/	Surge	Other
Inspection Strip in Tube			Drawing	\vdash	Misrea				-				
		Marks/Cl			-	Drill Holes	\vdash	Off-set					
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